

ABSTRACT OF THE DISCLOSURE

A unit sand mold is produced within a mold making chamber in the casting line. The unit sand mold has cavities on the front and rear faces in the line direction.

5 A plurality of unit sand molds thus produced are connected by joining the front face of one unit sand mold to the rear face of the preceding unit sand mold to form a train of connected sand molds. Molten aluminum or aluminum alloy is injected into the cavity through an injection port provided

10 at the boundary between the joined faces. The train of connected sand molds is then divided by cutting at a substantially central portion of each unit sand mold or of every nth unit sand mold (n is an integer of two or more) and the unit sand mold(s) is/are dipped in water to be

15 cooled. The sand mold is then dismantled, and sand thus obtained is dried and supplied to the mold making chamber for reuse.